

NCL-19-7557



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18640-101-PO
Job Sheet 191945



Part No: RBT18640-101-PO

Job Qty: 6 pcs

Part Name: Engine Removal Adapter



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/13/19

Job Tracking No:

Due Date: 5/8/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBT18640-101 Rev.5 IPP Rev. A 19.03.12 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	6 pcs		5/8/19	0.00	0.00	Purchasing - 1		MAY 09 2019
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	6 pcs		5/8/19	0.00	0.00	Packaging 2 - 1 - B4B		MAY 09 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		



Container No: S179567



Part: RBT18640-101

Job No: 191945

Serial No/Batch: S179567

Revision: 5

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/09/19

Plex 3/13/19 10:57 AM dart.Lussier.Patrick

					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120 QC 6	6 pcs	5/8/19	0.00 0.00	QC 6 - 42		
				QC 6 - 9		DAS
				QC 6 - 68		MAY 09 2019 68
				QC 6 - 61		9-89
125 External Load - 2 - B4B	6 pcs	5/8/19	0.00 1.50	External Load - 1 - B4B		
				External Load - 2 - B4B		
				External Load - 3 - B4B		
130 Small Fab - 2 - B4B	6 pcs	5/8/19	0.00 0.60	Small Fab - 1 - B4B		
				Small Fab - 2 - B4B		
				Small Fab - 3 - B4B		
				Small Fab - 4 - B4B		
				Small Fab - 5 - B4B		
				Small Fab - 6 - B4B		
				Small Fab - 7 - B4B		
140 QC 5	6 pcs	5/8/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 42		DAS
				QC 5 - 43		19
				QC 5 - 49		9-89
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
150 Packaging 3-1 - Stock - B4B	6 pcs	5/8/19	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		DAS
				Packaging 3 - 15 - B4B		21
				Packaging 3 - 16 - B4B		9-89
160 QC 21 - FG	6 pcs	5/8/19	0.00 0.00	QC 21 - FG - 21		DAS
				QC 21 - FG - 70		21
				QC 21 - SA - 53		9-89

Part Op 100 - Issue P/O: 0428791 MANUFACTURE RBT18640-101 AS PER DWG Supplier: ARROW TECH MACHINE
 Descriptions: WORKS -Certificate of conformity is required
 125 - Load test as per drawing sheet 2 note 1.
 130 - 1- Engrave T/N and/or P/N on RB 41011 placard using MARKTRONIC engraver as per DWG. 2-Install placard using #2 drive screws

x6 plus 13 March 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBT18640-101P	Engine Removal Adapter	6 Ea (1 ea)	100-Purchasing	<u>3179566</u>
90081A074	0.125 X 0.500 #2 Drive Screw	24 Ea (4 ea)	130-Small Fab - 2 - B4B	<u>562133</u>
RB41011	Dart Tooling Placard, Aluminum	6 Ea (1 ea)	130-Small Fab - 2 - B4B	<u>5021040</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBT18640-101P	6	0	0
130-Small Fab - 2 - B4B	90081A074	24	139	0
	RB41011	6	380	0

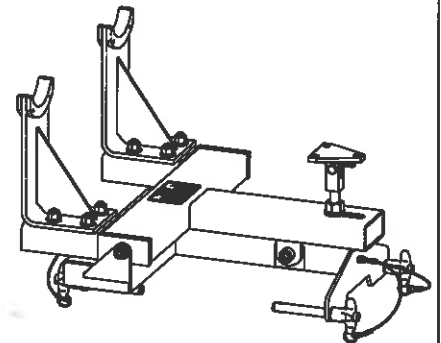
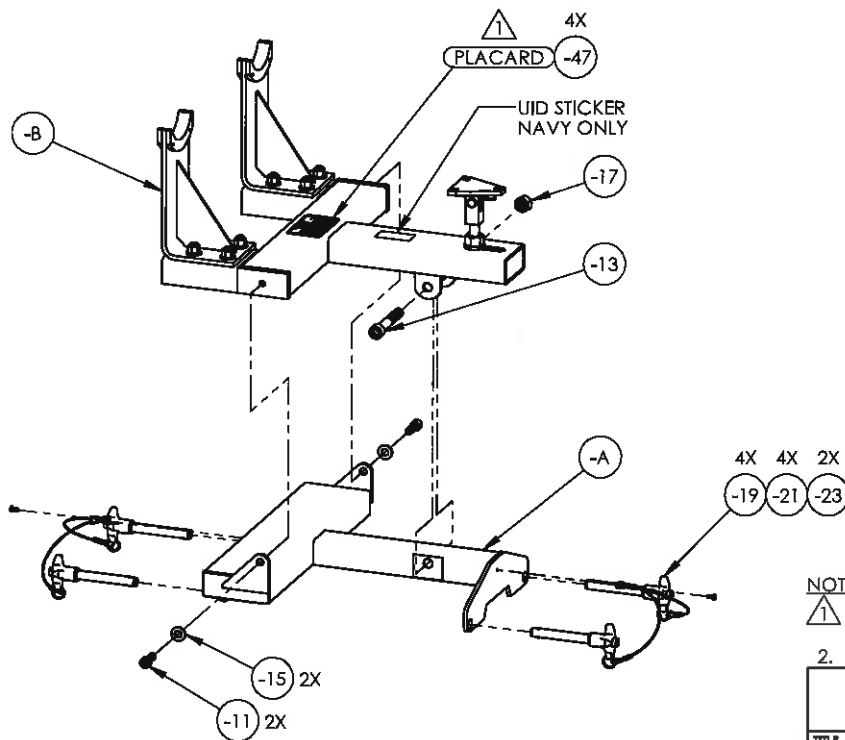
Part Specifications

Specifications could not be found.

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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED

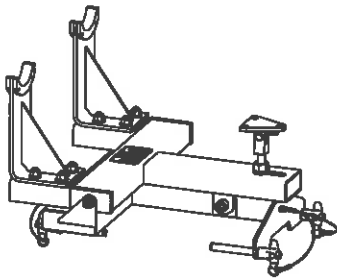


NOTES:

- △ RB41009 RED BARN PLACARD FOR NAVY ONLY, RB41011 DART PLACARD FOR ALL OTHERS.
- MADE TO FIT RBT18640 JACKING ASSEMBLY.

DART AEROSPACE	
TITLE ENGINE REMOVAL ADAPTER	
DWG NO. RBT18640-101	REV 5
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES XXX ± .005 XX ± .01 X ± .1	DRAWN BY: PERRITT APPROVED: <i>D. Weil</i> REAL DRAFT FINISH SPEC
1. BREAK ALL SHARP EDGES .016 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLAYING	USED ON MODEL FIRE SCOUT
SCALE 1:8	DATE 8/10/2007
SHEET 1 OF 11	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		EXTENDED -5 BY .025, MOVED -1 PIN HOLES DOWN .063, DELETED TWO LANYARD SCREW HOLES AND CENTER REMAINING TWO, ADDED CUT OUT FOR FUTURE TILT ADJUSTMENT OPTION, SHORTENED -7 BY .075, ADDED 45° SIDE TO -3, CREATED -25, ADDED UPPER PORTION OF 269T3301 TO UNIT, AND -11 WAS Ø1/2X1/2 SHOULDER BOLTS, ELIMINATED WASHERS LANYARD SCREWS CHANGED FROM #6 TO #8.	10/11/2007	WP	DW
2		DELETED NOTE 1, ADDED NOTES 2 & 3, CHD ALL BOM HARDWARE FROM PLAIN STEEL TO S.S. & ADDED P/N'S.	8/29/2011	RJC	-
3		CHD -7 OVERALL LENGTH FROM 15.915 MIN AND ADDED TOLERANCE PER G.E.	12/2/2011	RJC	GE
3*		-A ADDED FINISH POWDER COAT WHITE, ADDED -15, -45, -1 CHD DIMS WAS 4X 2.562 IS 2X 2.562, CHD B/O INFO WAS 3/16 X 3 X 9-1/2 IS 3/16 X 3 X 9-5/8, -3 CHD B/O INFO WAS 3/16 X 2-3/4 X 2-1/4 IS 3/16 X 2-7/8 X 2-1/4, -1, -3, -25 CHD DIM WAS .19 IS (.19), -6 CHD DIMS WAS .120 IS (.120), WAS .50 IS (.50), WAS 2.00 IS (2.00), CHD B/O INFO WAS .120 X 2 X 1-1/2 X 10-3/8 IS 120 X 2 X 1-1/2 X 10-1/2, -7 CHD DIMS WAS .120 IS (.120), WAS 1.50 IS (1.50), WAS 4.00 IS (4.00), -25 CHD B/O INFO WAS 3/16 X 2-1/4 X 4-1/2 IS 3/16 X 2-1/4 X 4-5/8.	6/4/2014	DPD	RJC
5	15-0348	UPDATED TO NEW STANDARDS, -27, -29, -31, -33, -35, -37, -39, -41 REMOVED DASH NUMBERS, -A DELETED DIM 1/32, CHD DIMS WAS 8-9/16 IS (8.56), WAS 7-5/16 IS 2X 7.300±.015, WAS 1 IS (1.063), WAS 1-1/2 IS 1.56, -1 CHD DIMS WAS 2X #8-32 UNC THRU IS 8-32 UNC -28 THRU ALL WAS (.19) IS (.19), WAS 2X .60 IS (2X .60), WAS 2X 1.678 IS 2X 1.68, WAS 2X 2.111 IS 2X 2.11, -8 CHD DIMS WAS .500 IS .50, WAS 1.813 IS 1.81, WAS (.19) IS (.19), -5 CHD DIMS WAS 10.400 IS 10.40, WAS 2X SKIM .040 IS (2X SKIM .040), WAS 2X .500 IS .500, WAS (.120) IS (.12), WAS (1.50) IS 1.50, WAS (2.00) IS 2.00, -7 CHD DIMS WAS 7.958 IS 7.96, WAS (1.50) IS 1.50, WAS (4.00) IS 4.00, WAS (.120) IS (.12), WAS 8-32 UNC ONE SIDE IS 8-32 UNC -28 3/16, -9 CHD DIM WAS (1.05 12pt) IS .10 (12pt), -25 CHD DIMS WAS 45° IS 2X 45°, WAS (.21) IS (2X .21), WAS (.19) IS (.19), -45 DELETED FROM BOIL, -47 ADDED TO BOM.	3/21/2016	DPD	JAG

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-A	1	BOTTOM ADAPTER ASSEMBLY			3
	1		-1		FRONT MOUNT	A709 GRADE 36 A		4
	2		-3		SIDE TABS	A709 GRADE 36 A		5
	1		-5		CENTER TUBE	STEEL TUBE A		6
	1		-7		REAR TUBE	STEEL TUBE A		7
	2		-9		END CAPS	A709 GRADE 36 A		8
8		B/O	-11	2	S.H.C. SCREWS	S.S.	3/8-16 X 1 (MCMMASTER-CARR #92196A624)	1 & 10
		B/O	-13	1	S.H.C. SCREW	S.S.	1/2-13 X 3-1/4 (92196A725)	1
8		B/O	-15	2	WASHER	S.S.	Ø3/8 (MCMMASTER-CARR #96659A106)	1 & 10
		B/O	-17	1	NYLON INSERT LOCK NUT	S.S.	1/2-13 (MCMMASTER-CARR #91831A137)	1
		B/O	-19	4	T-HANDLE QUICK RELEASE PINS	S.S.	Ø1/2 X 3 (ESSENTA COMPONENTS #BLTS-140)	1
		B/O	-21	4	LANYARDS W/ NYLON COATING	S.S.	Ø1/16 X 8 (ESSENTA COMPONENTS #FFC-210)	1
		B/O	-23	2	BUTTON H.C. SCREWS	S.S.	8-32 X 3/8 (MCMMASTER-CARR #92949A192)	1
	2		-25		REAR TABS	A709 GRADE 36 A		9
8		B/O	-43		NYLON INSERT NUTS	S.S.	3/8-16 (MCMMASTER-CARR #91831A127)	10
		B/O	-47	4	#2 DRIVE SCREW	COATED STEEL	#2 X 1/8 (MCMMASTER-CARR #90081A074)	1
X			-8	1	UPPER ADAPTER ASSEMBLY			10
1					CARRIAGE WELDMENT		269T3301-14	10
2					CRADLE ARM ASSEMBLY		269T3301-18	10
1					NUT PLATE WELDMENT		269T3301-21	10
1		B/O			CLEVIS PIN		269T3301-22	10
1		B/O			FLANGE NUT		269T3301-23	10
1		B/O			HAIR PIN		269T3301-24	10
1					STUD WELDMENT		269T3301-25	10
1					FRONT ENGINE MOUNT WELDMENT		269T3301-27	10
		B/O		1	PLACARD	ALUMINUM	RB41009 RED BARN OR RB41011 DART; SEE NOTE A SHEET 1	1
ASSY -8	ASSY -A							

NOTES:

1. UNIT IS TO BE WEIGHT TESTED TO 400 LBS.
2. THIS IS THE GENERIC PLATE SPEC FOR WHAT IS COMMONLY REFERRED TO AS 1018.
3. MATERIAL MAY VARY DEPENDING ON COMMERCIAL AVAILABILITY.



ENGINE REMOVAL ADAPTER

DWG NO. RBT18640-101		REV 5
MATERIAL UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: PERRITT
APPROVED: D. Weil		DATE: 8/10/2007
X.XXX ± .005 FRACTIONS ± 1/8		FINISH: .015
X.X ± .01 ANGLES ± .5°		SPEC: USED ON MODEL
1. BREAK ALL SHARP EDGES .015 X 45°		FIRE SCOUT
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		
SCALE: 1:10	DATE: 8/10/2007	SHEET 2 OF 11

3/13/2019

PURCHASE ORDER



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042879



Supplier: ARR002-VU Arrow Tech Machine Works 29751 E. Enid Road, Unit C Eugene, OR 97402 USA Phone: 541-780-6938 Fax: 458-215-4938		PO No: PO042879 PO Date: 3/13/19 Due Date: 5/8/19 Purchase Order Revision: Revision Date: Ship-To Contact: Phone:	
Attention: , Ana (541) 780-6938		Pymt Terms: Net 30 Freight Terms: Special Comments:	
Ship To:			

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	191945	RBT18640-101P			Engine Removal Adapter REV 5	Firmed	-	5/8/19	6 Ea	0 Ea	6 Ea	\$2,200.00/Ea	\$13,200.00
Grand Total:													\$13,200.00

Order Notes

Procurement Quality Clauses
 A005 RIGHT OF ENTRY
 A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
 A012 CHEMICAL AND PHYSICAL TEST REPORTS
 A016 PERSONNEL QUALIFICATION
 A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
 A026 CERTIFICATION OF MATERIAL CONFORMANCE
 A041 QUALITY MANAGEMENT SYSTEM
 A042 DART NOTIFICATION BY SUPPLIER
 A043 RETENTION OF QUALITY DOCUMENT
 A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
 A049 SUPPLIER AWARENESS



RECEIVED
 3/13/19 ANP

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042879



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

Attention: , Ana
(541) 780-6938

Ship To:

PO No: PO042879

PO Date: 3/13/19

Due Date: 5/8/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	191945	RBT18640-101P			Engine Removal Adapter REV 5	Firmed		5/8/19	6 Ea	0 Ea	6 Ea	\$2,200.00/Ea	\$13,200.00
Grand Total: \$13,200.00													

Order Notes

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A042 DART NOTIFICATION BY SUPPLIER

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A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 538

Date: 4/25/2019 ✓
PO Ref: 042879 ✓
Ship via: FREIGHT

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty ✓

6

Item

ENGINE REMOVAL ADAPTER

Part No. ✓

RBT18640-101

Received by:

Packaged by: J.M.L.

Checked by: Hair

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: 042879 ✓ Dated: 4/25/2019

Our Order / Job No: 042879-1AWT Order Qty: 6 ✓

Part Name: ENGINE REMOVAL ADAPTER

Part Number RBT18640-101 ✓

Lot Size: N/A Ship Date: 4/25/2019

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBT18640-101/ ASSY "A" & ASSY "B" Rev: 5

269T3301-14 REV -14

Material Size and Type: ASSY A: PLATE A36 STEEL -1, -3, -9, -25 / STEEL TUBE -5, -7

ASSY B: 1018 STEEL-9, -11, -7, -17, -21, -27/ STEEL TUBE -13, -15,
-19/DELRIN;

Material Specifications: 1018 PLATE AND TUBING: ASTM A108; STEEL ASTM A36; DELRIN:
D6100

Heat Treatment: N/A

Plating/Finish: POWDER COAT WHITE; BLACK ZINC: ASTM 633 TYPE II SC2

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com



ARROW TECH MACHINE WORKS

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 4/25/19

Signed: Hemant M. Patel

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com

RED BARN MACHINE

TITLE INSPECTION & TESTING PROCEDURES
FOR THE ENGINE REMOVAL ADAPTER

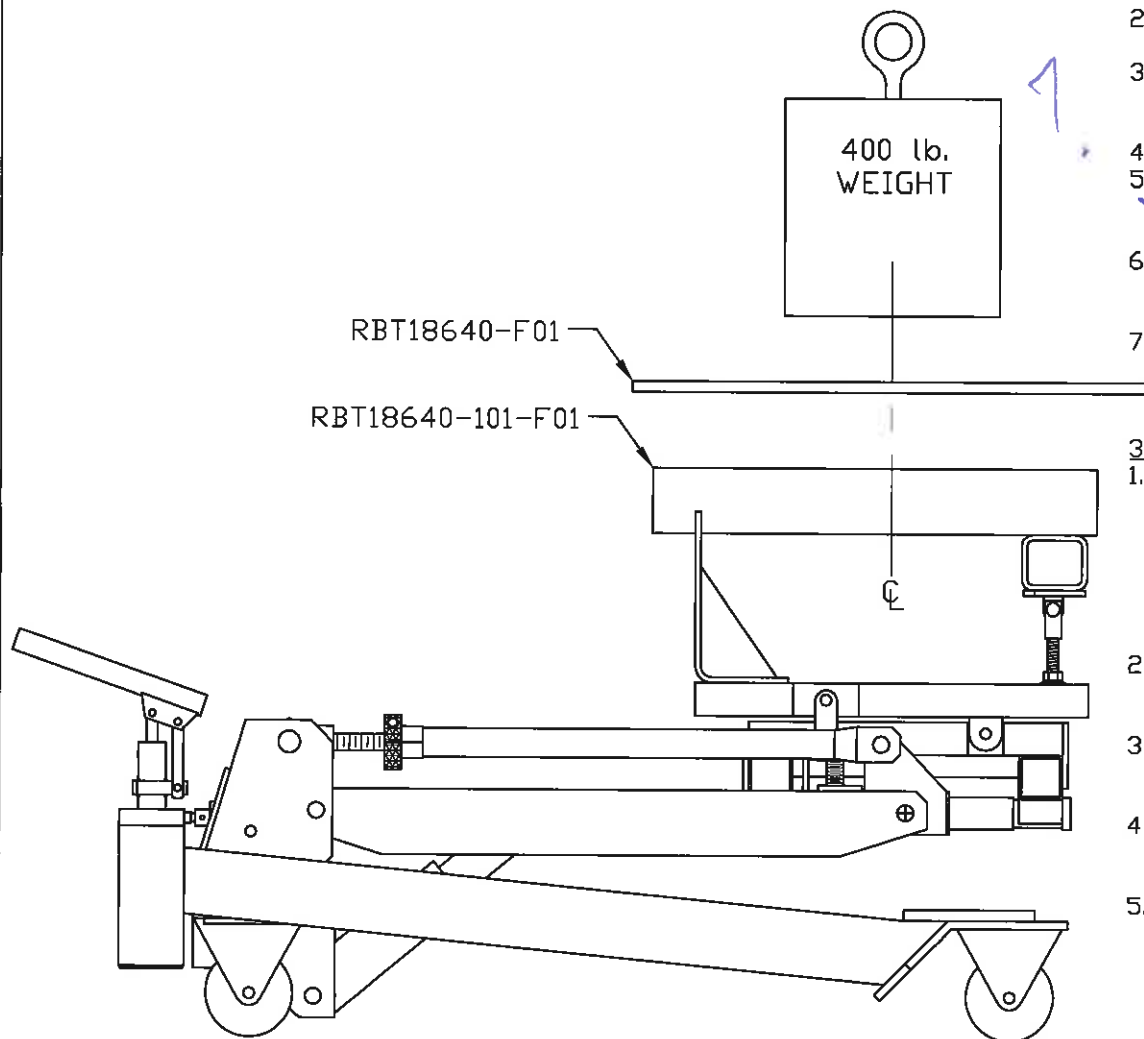
TOOL NO. RBT18640-101-TEST

RED BARN MACHINE

190 S. DANEBO AVE., Eugene, Oregon 97402

(541) 344-9953; fax (541) 344-3863

e-mail; sales@redbarn.net



INSPECTION & TESTING PROCEDURES FOR THE ENGINE REMOVAL ADAPTER RBT18640-101. THE RBT18640-101 IS DESIGNED FOR THE INSTALLATION, AND THE REMOVAL OF THE FIRE SCOUT ENGINE. THIS ASSEMBLY SHOULD BE INSPECTED BEFORE AND AFTER EACH USE. REPLACE ANY ITEMS THAT ARE DAMAGED OR SUSPECTED OF DAMAGE BEFORE USING!

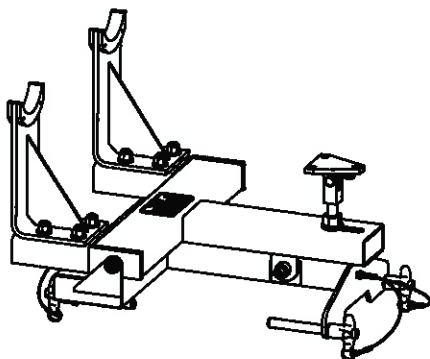
91 DAY INSPECTION:

1. CLEAN ENTIRE UNIT AND REMOVE CORROSION. CHECK BOTTOM MOUNTING TABS FOR DISTORTIONS OR CRACKS.
2. CHECK THE MOUNTING TABS BETWEEN THE TOP AND BOTTOM ASSEMBLIES FOR DISTORTIONS OR CRACKS.
3. CHECK ALL BOLTS, BALL LOCK PINS, FRONT PAD SWIVEL AND ADJUSTING STUD FOR DAMAGE, DISTORTION, AND CRACKS. TIGHTEN IF NECESSARY.
4. CHECK BOTH CRADLE PADS FOR DAMAGE AND CRACKS.
5. MOUNT THE RBT18640-101 ENGINE REMOVAL ADAPTER ASSEMBLY ON TO THE RBT18640 JACK OR THE RBT18640-F03 JACK REPLACEMENT TESTING FIXTURE.
6. TEST AND INSERT ALL FOUR BALL LOCK PINS, LOCKING THE TWO UNITS TOGETHER. THE UNITS ARE NOW READY FOR USE.
7. REPAINT IF NECESSARY. OIL ALL HINGES AND HEIGHT ADJUSTING SCREWS WITH MIL-L-7870 GENERAL PURPOSE LUBRICATING OIL.

3 YEAR WEIGHT TESTING:

1. AFTER INSPECTION, WITH THE RBT18640-101 SECURELY FASTENED TO THE RBT18640 JACK OR THE RBT18640-F03 JACK REPLACEMENT TESTING FIXTURE, PLACE THE RBT18640-101-F01 FIXTURE INTO THE ADAPTER SADDLES AS SHOWN. ATTACH THE FRONT SWIVEL MOUNT TO THE FIXTURE WITH THE FIXTURE SCREWS.
2. CENTER THE FIXTURE PLATE RBT18640-F01 OVER THE ENGINE ADAPTER ASSEMBLY AND PLACE IT ON RBT18640-101-F01 FIXTURE.
3. WITH THE JACK IN THE LOWERED POSITION PLACE A 400 LB WEIGHT ON THE CENTER OF FIXTURE PLATE RBT18640-F01.
4. LEAVE WEIGHT IN PLACE FOR 5 MINUTES WHILE OBSERVING FOR BENDING AND DISTORTIONS. AFTER 5 MINUTES REMOVE THE WEIGHT AND FIXTURES.
5. RE-INSPECT ENTIRE ASSEMBLY.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		EXTENDED -.5 BY .025, MOVED -1 PIN HOLES DOWN .063, DELETED TWO LANYARD SCREW HOLES AND CENTER REMAINING TWO, ADDED CUT OUT FOR FUTURE TILT ADJUSTMENT OPTION, SHORTENED -7 BY .075, ADDED 45° SIDE TO -3, CREATED -25, ADDED UPPER PORTION OF 269T3301 TO UNIT, AND -11 WAS Ø1/2X1/2 SHOULDER BOLTS. ELIMINATED WASHERS LANYARD SCREWS CHANGED FROM #6 TO #8.	10/11/2007	WP	DW
2		DELETED NOTE 1, ADDED NOTES 2 & 3, CH'D ALL BOM HARDWARE FROM PLAIN STEEL TO S.S. & ADDED P/N'S.	8/29/2011	RJC	-
3		CH'D -7 OVERALL LENGTH FROM 15.915 MIN AND ADDED TOLERANCE PER G.E.	12/2/2011	RJC	GE
3A		-A ADDED FINISH POWDER COAT WHITE. ADDED -15, -45, -1 CH'D DIMS WAS 4X 2.562 IS 2X 2.562, CH'D B/O INFO WAS 3/16 X 3 X 9-1/2 IS 3/16 X 3 X 9-5/8, -3 CH'D B/O INFO WAS 3/16 X 2-3/4 X 2-1/4 IS 3/16 X 2-7/8 X 2-1/4, -1, -3, -25 CH'D DIM WAS .19 IS (.19), -5 CH'D DIMS WAS .120 IS (.120), WAS 1.50 IS (1.50), WAS 2.00 IS (2.00), CH'D B/O INFO WAS .120 X 2 X 1-1/2 X 10-3/8 IS .120 X 2 X 1-1/2 X 10-1/2, -7 CH'D DIMS WAS .120 IS (.120), WAS 1.50 IS (1.50), WAS 4.00 IS (4.00), -25 CH'D B/O INFO WAS 3/16 X 2-1/4 X 4-1/2 IS 3/16 X 2-1/4 X 4-5/8.	6/4/2014	DPD	RJC
5	15-0348	UPDATED TO NEW STANDARDS. -27, -29, -31, -33, -35, -37, -39, -41 REMOVED DASH NUMBERS. -A DELETED DIM 1/32. CH'D DIMS WAS 8-9/16 IS (8.56), WAS 7-5/16 IS 2X 7.300±.015, WAS 1 IS (1.063), WAS 1-1/2 IS 1.56, -1 CH'D DIMS WAS 2X #8-32 UNC THRU IS 8-32 UNC -28 THRU ALL, WAS (.19) IS .19, WAS 2X 60° IS (2X 60°), WAS 2X 1.678 IS 2X 1.68, WAS 2X 2.111 IS 2X 2.11, -3 CH'D DIMS WAS .500 IS .50, WAS 1.813 IS 1.81, WAS (.19) IS .19, -5 CH'D DIMS WAS 10.400 IS 10.40, WAS 2X SKIM .040 IS (2X SKIM .040), WAS 2X .500 IS .500, WAS (.120) IS .12, WAS (1.50) IS 1.50, WAS (2.00) IS 2.00, -7 CH'D DIMS WAS 7.958 IS 7.96, WAS (1.50) IS 1.50, WAS (4.00) IS 4.00, WAS (.120) IS .12, WAS 8-32 UNC ONE SIDE IS 8-32 UNC -28 Ø .13, -9 CH'D DIM WAS (.105 (2ga) IS .10 (12ga), -25 CH'D DIMS WAS 45° IS 2X 45°, WAS (.21) IS (2X .21), WAS (.19) IS .19, -45 DELETED FROM BOM, -47 ADDED TO BOM.	3/21/2016	DPD	JAG

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w/o

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-A	1	BOTTOM ADAPTER ASSEMBLY			3
	1		-1		FRONT MOUNT	A709 GRADE 36 Δ		4
	2		-3		SIDE TABS	A709 GRADE 36 Δ		5
	1		-5		CENTER TUBE	STEEL TUBE Δ		6
	1		-7		REAR TUBE	STEEL TUBE Δ		7
	2		-9		END CAPS	A709 GRADE 36 Δ		8
8		B/O	-11	2	S.H.C SCREWS	S.S.	3/8-16 X 1 (MCMaster-CARR #92196A624)	1 & 10
		B/O	-13	1	S.H.C. SCREW	S.S.	1/2-13 X 3-1/4 (92196A725)	1
8		B/O	-15	2	WASHER	S.S.	Ø3/8 (MCMaster-CARR #96659A108)	1 & 10
		B/O	-17	1	NYLON INSERT LOCK NUT	S.S.	1/2-13 (MCMaster-CARR #91831A137)	1
		B/O	-19	1	FRONT MOUNT PLATE	ALUMINUM	FRONT MOUNT PLATE	1
		B/O	-21	4	LANYARDS W/ NYLON COATING	S.S.	Ø1/16 X 8 (ESSENTIA COMPONENTS #FPC-210)	1
		B/O	-23	2	BUTTON H.C. SCREWS	S.S.	8-32 X 3/8 (MCMaster-CARR #92949A192)	1
	2		-25		REAR TABS	A709 GRADE 36 Δ		9
8		B/O	-43		NYLON INSERT NUTS	S.S.	3/8-16 (MCMaster-CARR #91831A127)	10
		B/O	-47	4	#2 DRIVE SCREW	COATED STEEL	#2 X 1/8 (MCMaster-CARR #90081A074)	1
X			-B	1	UPPER ADAPTER ASSEMBLY			10
1					CARRIAGE WELDMENT		269T3301-14	10
2					CRADLE ARM ASSEMBLY		269T3301-18	10
1					NUT PLATE WELDMENT		269T3301-21	10
1		B/O			CLEVIS PIN		269T3301-22	10
1		B/O			FLANGE NUT		269T3301-23	10
1		B/O			HAIR PIN		269T3301-24	10
1					STUD WELDMENT		269T3301-25	10
1					FRONT ENGINE MOUNT WELDMENT		269T3301-27	10
		B/O		1	PLACARD	ALUMINUM	RB41009 RED BARN OR RB41011 DART; SEE NOTE Δ SHEET 1	1
ASSY -B	ASSY -A							

NOTES:

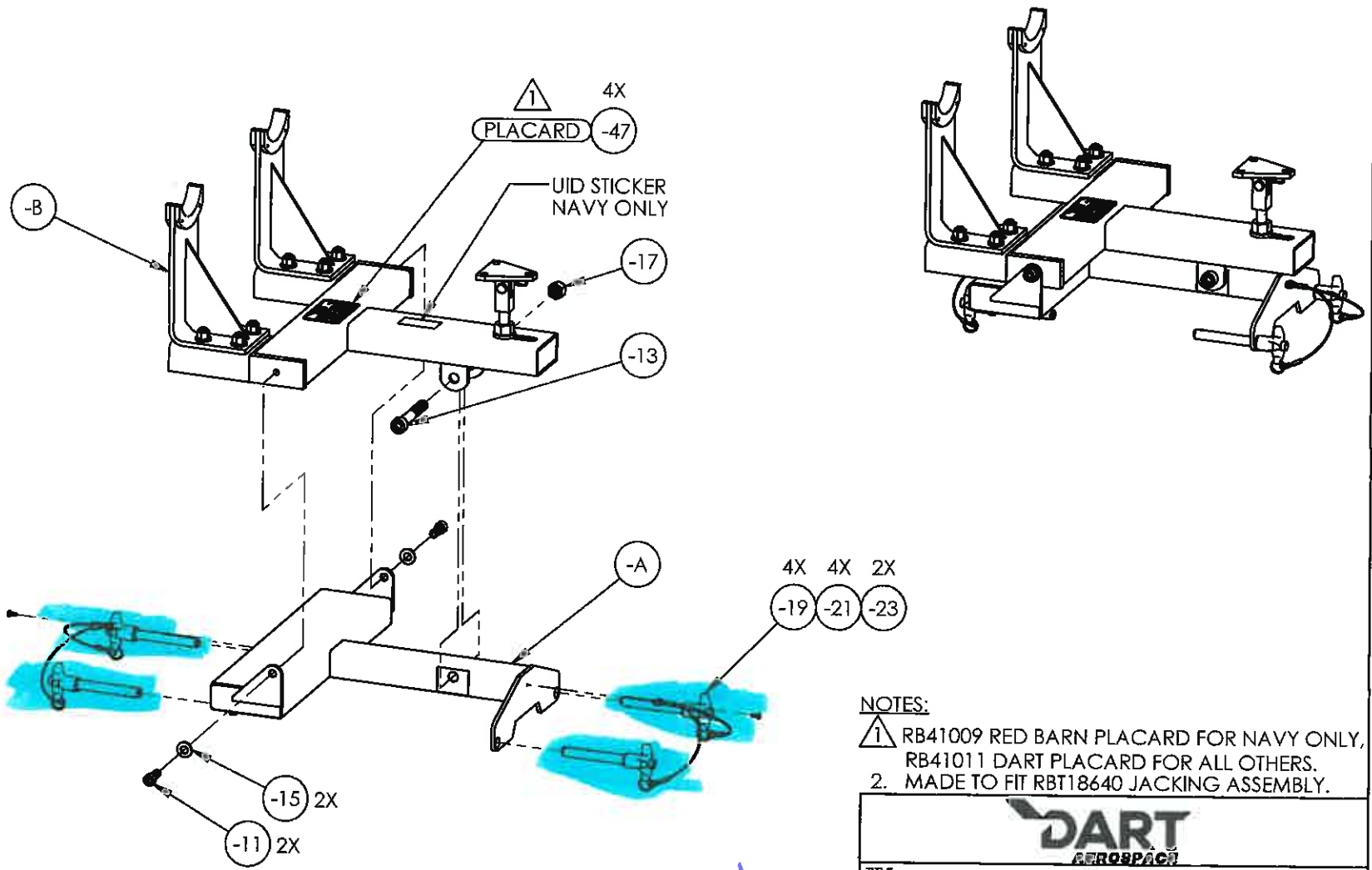
- UNIT IS TO BE WEIGHT TESTED TO 400 LBS.
- THIS IS THE GENERIC PLATE SPEC FOR WHAT IS COMMONLY REFERRED TO AS 1018.
- MATERIAL MAY VARY DEPENDING ON COMMERCIAL AVAILABILITY.



TITLE		ENGINE REMOVAL ADAPTER	
DWG NO.		RBT18640-101	
REV		5	
MATERIAL		DRAWN BY: PERRITT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED: <i>[Signature]</i>	
.XXX ± .005 FRACTIONS ± 1/8		HEAT TREAT	
.XX ± .01 ANGLES ± 5°		FINISH	
.X ± .1		SPEC	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		FIRE SCOUT	
SCALE	1:10	DATE	8/10/2007
		SHEET 2 OF 11	

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REVISIONS			
REV	ECR	DESCRIPTION	
		DATE	INITIAL
			APPROVED



- NOTES:
- 1. RB41009 RED BARN PLACARD FOR NAVY ONLY, RB41011 DART PLACARD FOR ALL OTHERS.
 - 2. MADE TO FIT RBT18640 JACKING ASSEMBLY.

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DAS w/o*

DART AEROSPACE	
TITLE ENGINE REMOVAL ADAPTER	
DWG NO. RBT18640-101	REV 5
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° X ± .1	DRAWN BY: PERRITT APPROVED: <i>D Perritt</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .016R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL FIRE SCOUT
SCALE 1:8	DATE 8/10/2007
SHEET 1 OF 11	

Entered: 1h Date: MAY 30 2019

LOAD TEST



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 19-7557

Route update only ☐

Job: <u>191945</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
Part No. <u>RBT18640-101-TEST</u>		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☒ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier Quality ☐

Date: _____ Sequence #: _____ QTY Affected: 6 MRB (QSI042)

Description Work Order Deviation	Disposition	Completed By
INSPECTION & TESTING PROCEDURE FOR ENGINE REMOVAL ADAPTER RBT18640-101-PO JOB191945 REFER TO sheet (INSPECTION & TESTING PROCEDURE) TESTED 400LB LOAD ON ALL BALL LOCK PINS RE-INSPECT ETIRE ASS - (PASSED)	RE-INSPECT TEST WAS SUCCESSFULL and PASSED INSPECTION	<u>CPC MAY/30</u> MAY 30 2019 Lead hand / Supervisor <u>24</u> 9-89 MAY 30 2019 QC / QA Coordinator <u>68</u> 9-89 MAY 30 2019

Root Cause	FAULT CATEGORY			
☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☒ Human Factors	☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread

Other/Details: TEST WAS SUCCESSFULL and PASSED INSPECTION